

Work Order ID 82373

March-30-12 7:42:43 AM

82373

Page 1

Item ID: D2500-1-100

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Extrusion

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 60.00

80

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/30

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2500	RevH

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

0.00

Issue P/O: 116620

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 100" long
- g) Bon L. Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

CL 12/04/02 78

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

Ensure material certification is attached

12/4/12 78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82373

82373

Page 2

March-30-12 7:42:43 AM

Item ID: D2500-1-100

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Extrusion

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00	<i>inspects Skidstay</i>						
120		0.00	<i>QC</i>						
QC	Memo		<i>Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester</i>						
Quality Control									
130	Identify as per dwg & Stock Location: <i>H11-008</i>	0.00							
130			<i>QC Pull at 2000 Re QC spot inspect</i>						
Packaging	Memo								
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								
Quality Control									

2/9 12-5-7

12/5/8

12-05-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-30-12 7:42:46 AM

Page 1

Work Order ID: 82373

82373

Parent Item: D2500-1-100

D2500-1-100

Parent Item Name: Skidtube Extrusion

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: A05.11.14New Issue KJ/JLMIPP Rev:B as per dwg revH DD
verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100P *D2500-1-100P* Skidtube Extrusion		Purchased	No			110	Each	0.0000	1	60			
									**	42/3/27 (78)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.066 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG), D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 897105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18868

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG), D2500-3 EXTRUSION MANUFACTURED FROM:

- A) CARADON INDALEX DIE # MS-18867

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82373 MLJ

12/03/30

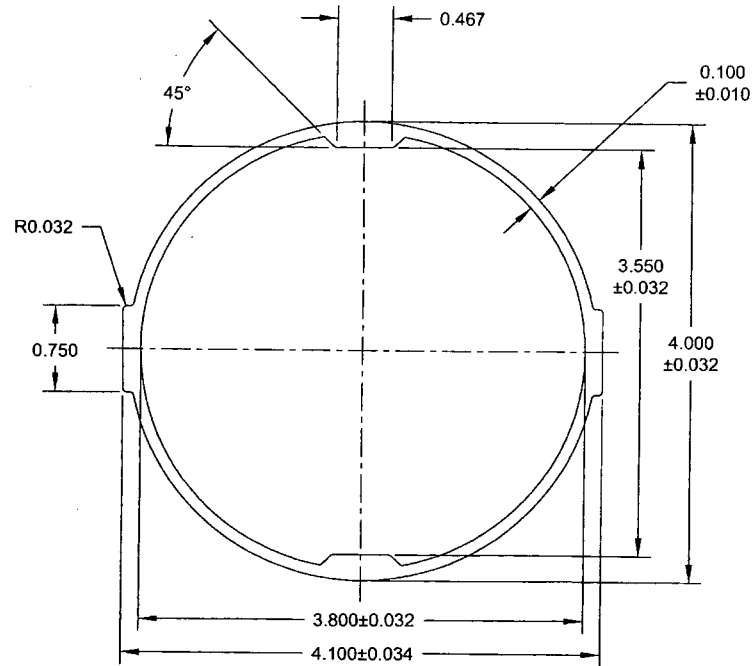
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REV.	DESCRIPTION	BY	DATE
H	REDRAW & REFORMAT DWG; CORRECT BON L DIE # TYPO (ZN B8-1); ADD AMS & ASTM MAT'L OPTION (ZN D8-1); TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & 'DIMS IN INCHES' NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.09.29
E	CHANGE MATERIAL TEMPER	DS	96.10.24
D	ADD MATERIAL PROPERTIES	DS	96.10.07
C	ADD D2500-3 WEB	BW	96.04.26
B	CHANGE INTERNAL WEB	DS	96.03.24
A	NEW ISSUE	DS	96.03.19
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	4		
CHECKED	PH		
MFG. APPR.	MT		
APPROVED	MT		
DE APPR.	MT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	09.07.16	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	

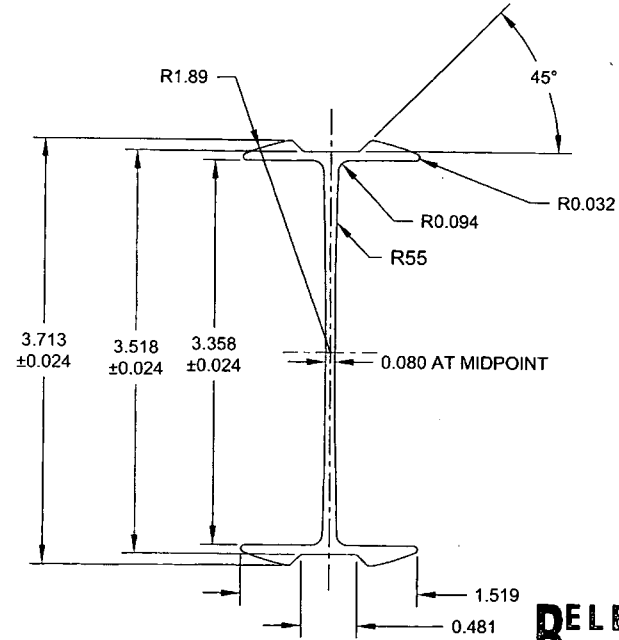
REV. H
SHEET 1 OF 2
SCALE
NTS
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8 7 6 5 4 3 2 1

82373



D2500-1



D2500-3

RELEASED
2010-02-02
MJP

DESIGN	4	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BT	DRAWING NO.	REV. H
MFG. APPR.		D2500	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	09.07.16	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16620

Purchase Order Date 4/02/12

PO Print Date 4/02/12

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

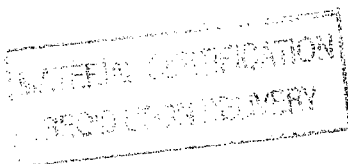


Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2500-1-100P	Skidtube Extrusion	4/27/12 Yes	78.00 Each	Yours ppd	\$43.6450	\$3,404.31

Special Inst: EXTRUDE AS PER D2500
B82373
MATERIAL: 6061-T6 AS PER QQ-A-200/8
MINIMUM YIELD TENSILE STRENGTH
= 35 KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%
DIE # 897105
TO BE PACKED PER DSK 066
PULL TEST TO ASTM STANDARD B221
REQUIRED

PO Total:

\$3,404.31



Change Nbr:

2

Change Date:

4/02/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

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ACCT# 46024

INVOICING AND COMPANY LOCATION

SHIPPING MANIFEST

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE / DATE DU BODEREAU
04-25-12

MANIFEST NUMBER / N° DE BODEREAU
005495

SALES ORDER NUMBER / N° DE COM
105265

SHIP TO / EXPÉDIÉ À
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA
PHONE: 613-632-5200

SOLD TO / VENDUE À
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA
PHONE: 613-632-5200

TERMS / FREIGHT
PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE
REFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT 46024		ORDER DATE / DE LA COM 04/02/12		CUSTOMER PO NUMBER / CLIENT PO Nombre 16620		JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		SALES REP / REP. DES VENTES G.ATTENBOROU	
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 005495		CARRIER / TRANSPORTEUR JODEE		SALES MAN / VENDEUR 042		CREDIT REP / REP DU CRÉDIT		CUST SERVICE REP / REP. SERVICE CLIENTELE DLB			
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,100 LB			DAA-897105-3	6061 T6		3	1,036	996	LB	
	499 KG			D2500-1-100	100.0000 IN			470	452	KG	
	78 PC				Cut(+): 0.1180 Cut(-): 0.0000 Min: 0 % Max: 0 %				73	PC	
						811824 / 138216	1	326	313		23 PC
						811824 / 138217	1	326	313		23 PC
						811824 / 138218	1	384	370		27 PC

78

3	1,036	996	LB
	470	452	KG
		73	PC
TOTALS			

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below
customers authorized representatives.
return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in
accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

STOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
04/20/2012	5282789	105265	1
Cust PO	B/L No	Lot	Date
16620	005495	811824	04/25/12

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No	Item Description	Cust Part
001	DAA-897105-3	100" MILL 6061 T6	D2500-1-100
Gross Weight	1,036 LBS		
Net Qty	996 LBS		
		73 PCS	3 PKGS
Specification		Die Desc	
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HREW
MPA / KSI	MPA / KSI			
290.4 / 42.1	257.3 / 37.3	11.8	0.0	91

8/2/04

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.61	0.33	0.23	0.06	0.84	0.07	0.22	0.02	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc